

Date: Monday, 9/18/2006 2:29:38 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPLATE	
Job Number	28639		Part Number	D25775	
Estimate Number	10299		Drawing Number	D2577 REV E	
P.O. Number	N/A		Project Number	N/A	
This Issue	9/18/2006	S.O. No.	11A	Drawing Revision	E
Prsh Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	10/5/2006	
Previous Run	28122		Qty:	50	
Written By			Um:	Each	
Checked & Approved By					
Comment	Est: F 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 1.0301 sf(s)/Unit Total : 51.5025 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: M102 372 (46) SAD 06:10:14 (46)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET Cut as per Dwg D2577 DWG REV: E Prog Release: S 2-Deburr if necessary SAD 06:10:14 (46)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1 SAD 06:10:23 (46)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK SAD 06:10:25 (46)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr SAD 06:11:12 (46)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/18/2006 2:29:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28639

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SB 06/11/14 46

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.5.5.6) as per QSI 005 4.3

m-h/a.m

06/12/15 46

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

yl

06/12/21 x 46

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP

yl

06/12/28

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 07/01/02

Job Completion



U 06.12.29

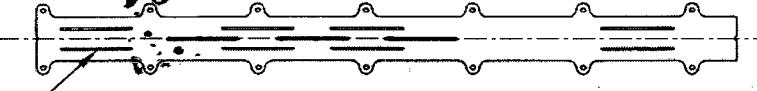
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

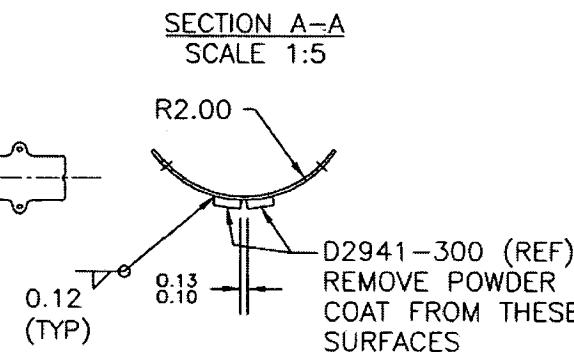
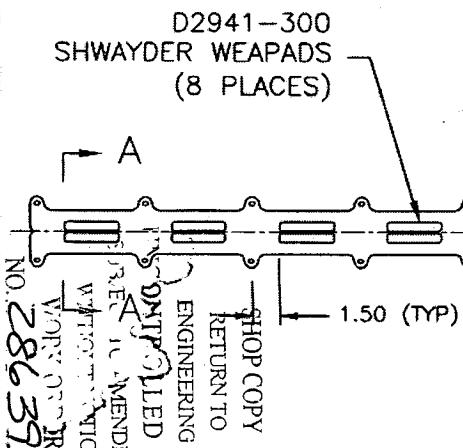
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

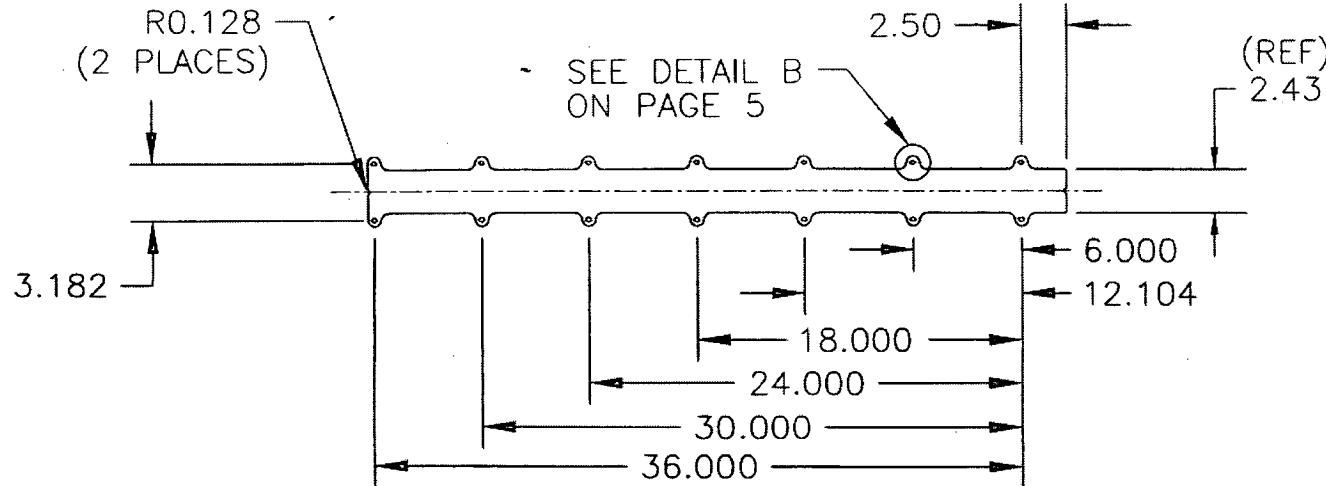
DART
04.26.97

RELEASED
04.26.97

DESIGN <i>off</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>off</i>	APPROVED <i>off</i>	DRAWING NO. D2577
DATE 00.09.22	TITLE WEARSHOE	REV. E SHEET 1 OF 5 SCALE 1:10
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO O-BOUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1996 by DART AEROSPACE LTD

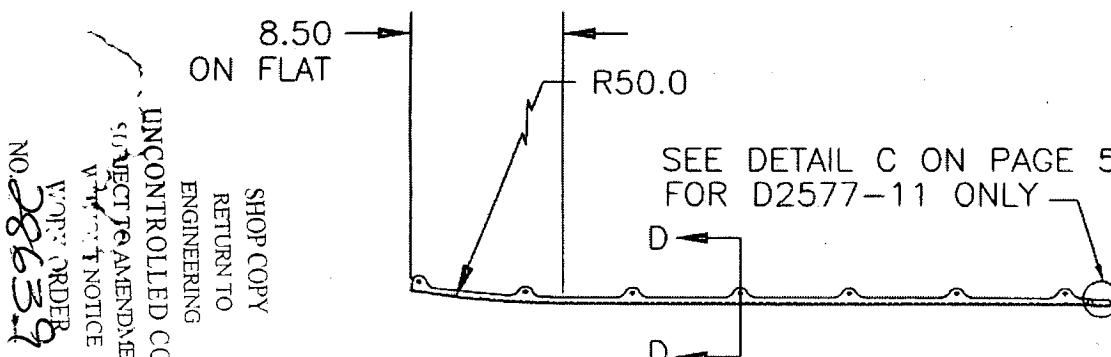


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
W/AMENDMENT NOTICE
WORK ORDER
NO. 28639

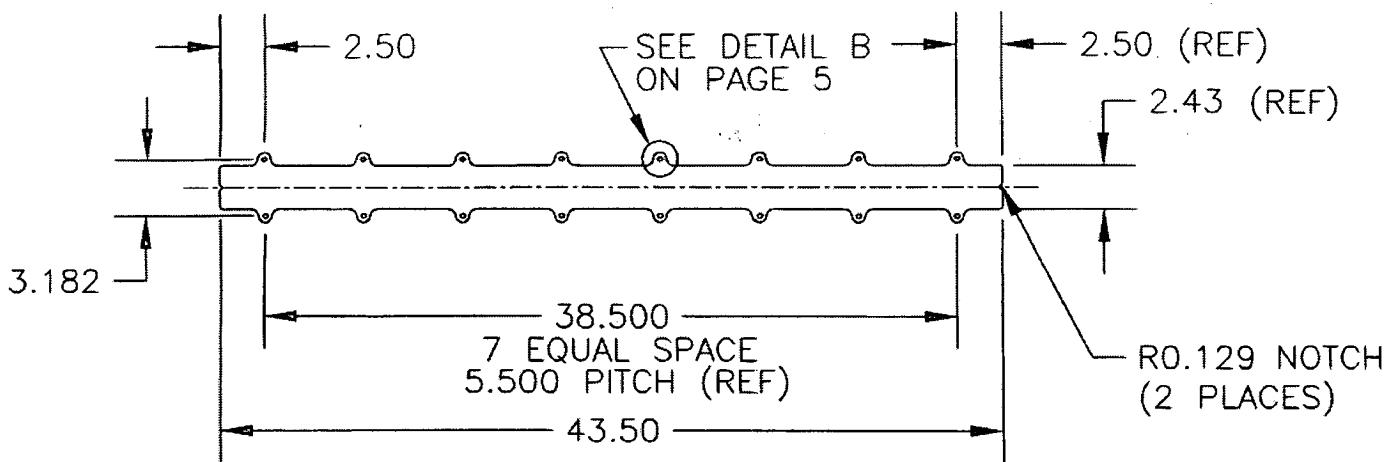
RELEASED
08.01.26

DESIGN	DRAWN BY	DART AEROSPACE LTD
✓	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D2577
DATE		REV. E
00.09.22	TITLE	SHEET 2 OF 5
	WEARSHOE	SCALE
		1:10

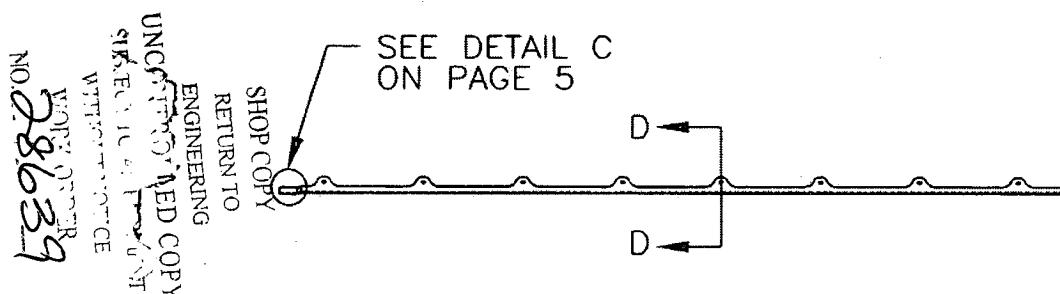
DART

DA COPY
08.01.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1996 by DART AEROSPACE LTD

DART

DA COPY
030

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	REV. E
DATE		DRAWING NO. D2577	SHEET 3 OF 5
00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

DART

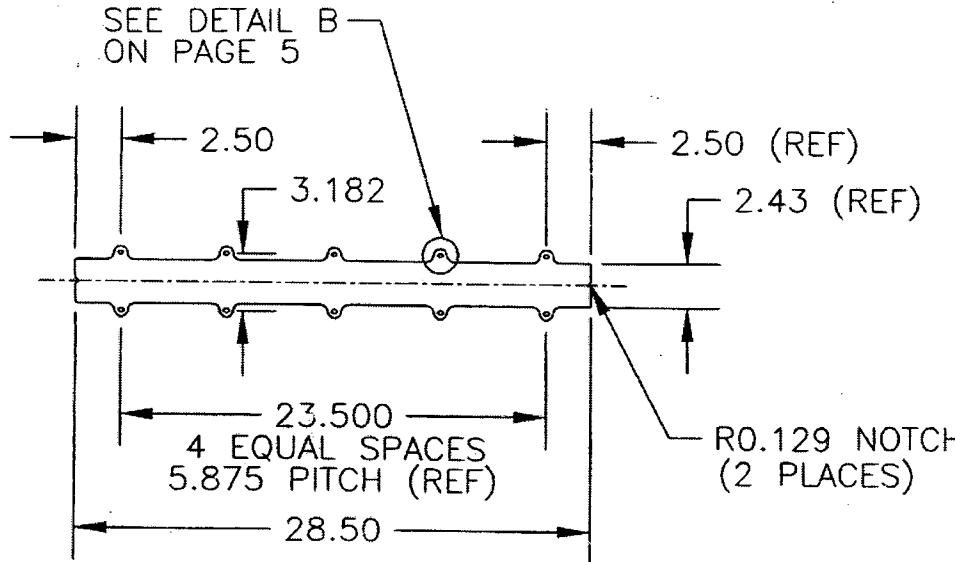


DESIGN	DRAWN BY	DART AEROSPACE LTD
	GJ	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
	GJ	D2577
DATE		SHEET 4 OF 5
00.09.22		SCALE
		1:10
		TITLE
		WEARSHOE

RELEASED
00 09 26 47

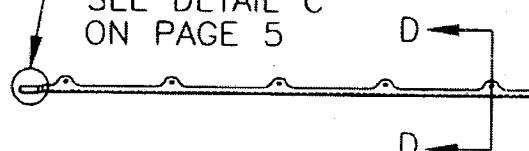
D2577-7 FLAT PATTERN

SEE DETAIL B
ON PAGE 5



D2577-7 LONGITUDINAL BEND

SEE DETAIL C
ON PAGE 5



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1996 by DART AEROSPACE LTD

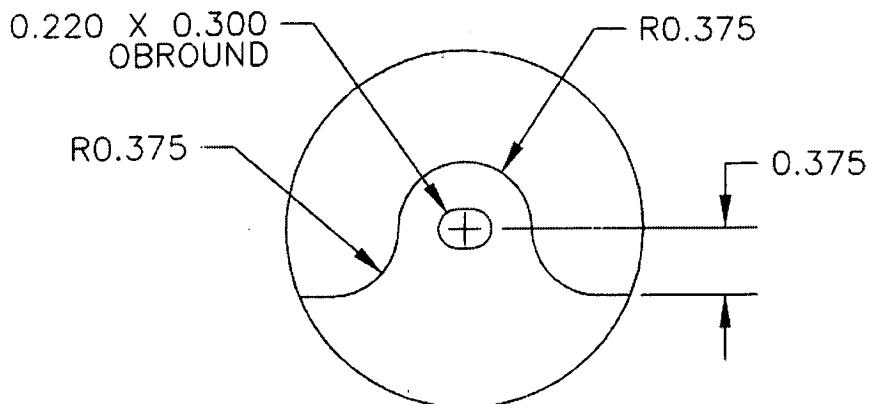
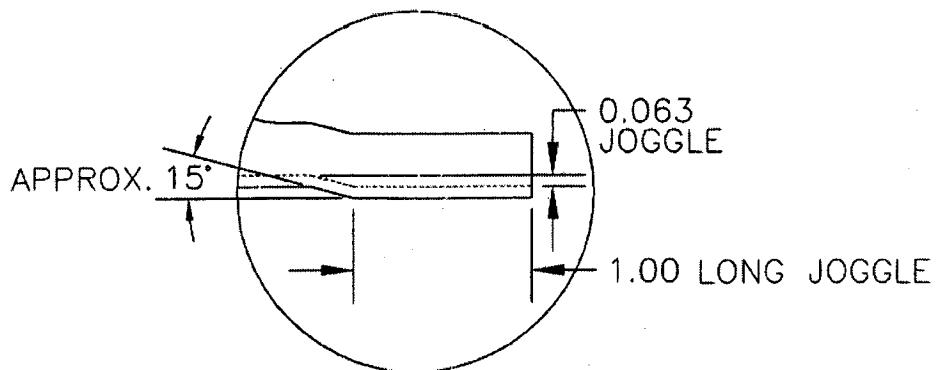
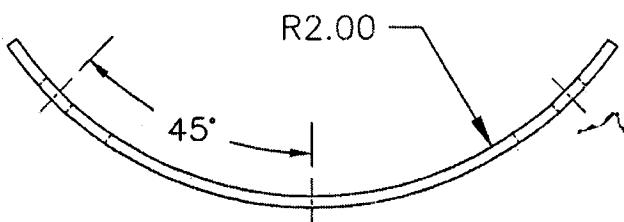
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO. 28639

SHOP COPY
RETURN TO
ENGINEERING
~~INFORMATION CONTROLLED COPY~~
SOME INFORMATION CONTAINING
COMPUTER GENERATED CODE
WHICH IS THE PROPERTY OF DART AEROSPACE LTD.
NOT TO BE REPRODUCED
WITHOUT WRITTEN CONSENT

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)**RELEASED**
00.09.26 *CP*DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28639*

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD

Work Order: 28639

Description:

Part Number: D25 745

Inspection Dwg:

Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

• X

First Article

x

Prototype

Measured by: W.D. WY
Date: SAM

Audited by:	<i>J</i>
Date:	06-10-25

Prototype Approval:	<i>N/A.</i>
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	